

5/13

DART AEROSPACE LTD	Work Order:	22542
Description: Spacer	Part Number:	D2808
Dwg: D2808 rev.A1	Qty:	100

05.02.23 05.02.23 0P

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue W/O	JF	05.02.24	100
2	COBRA	Machine as per Folio FA205 Material: 6061-T6 (QQ-A-250/11)or(QQ-A-225/8) rod .500"Ø Batch: M15811	JF	05.03.03	100
3	QC	Inspect level 2	JF	05.03.05	100
4	QC	Inspect Level 8	EC	05.03.03	100
5	CNC CELL	Tumble & deburr all sharp edges	JF	05.03.03	100
6	QC	Inspect Level 5	EC	05.03.03	100
7	FINISHING	Chemical conversion coat per QSI 005 4.1	MJ	05.03.09	100
8	FINISHING	Powder coat <u>white</u> per QSI 005 4.3	MJ	05.03.15	100
9	QC	Inspect Level 3	U	05.03.16	100
10	STORES	Identify and stock	U	05.03.16	100
11	EXPEDITING	Close W/O Inspect level 21 Cost / part: 1.49 S45 05/03/17 F00 1.49	JF	05.03.18	100

Rev	Date	Change	Revised By	Approved
A	00.11.06	New Issue	EC	
B	00.11.14	Revised inspection level 2 to 6	EC	
C	01.04.26	Re format	EC	
D	02.03.07	Now turned in house	NG	GPO2-03-11

RELEASED

02/03/11 JF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

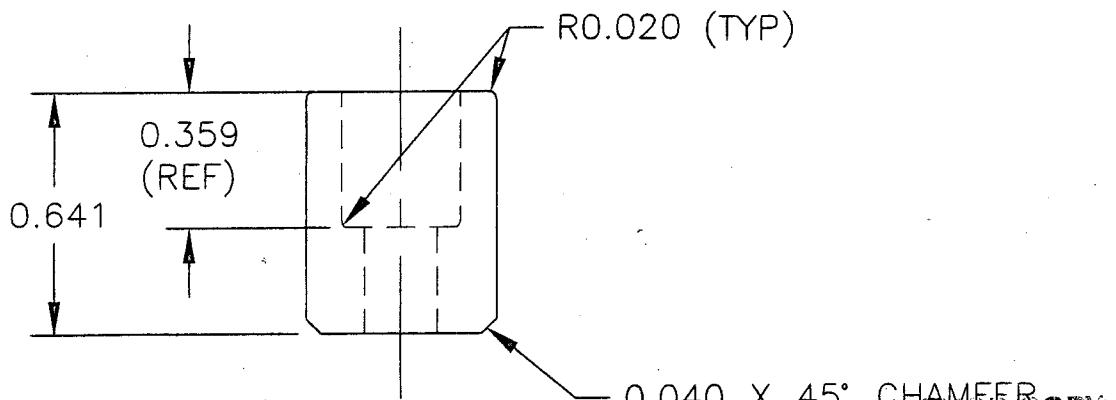
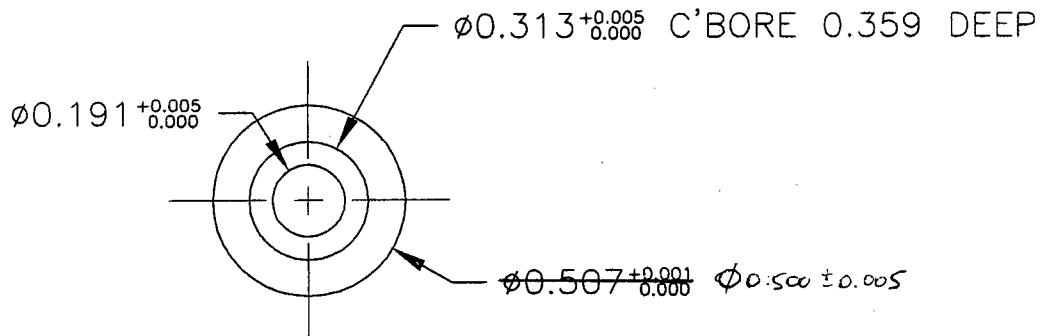
NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____



5 COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D2808	SHEET 1 OF 1
DATE		TITLE	SCALE
00.11.07		SPACER	2:1
A	00.11.07	NEW ISSUE	
A1	HP 01.04.26	ADD POWDER COAT; $\phi 0.500$ WAS $\phi 0.507$	

RELEASED
R C M. 13 #



SHARP COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 22542

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK ALL UNMARKED SHARP CORNERS 0.010 TO 0.020

MATERIAL: 6061-T6 (QQ-A-250/11) OR (QQ-A-225/8)

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

Powder coat white (4.3.5.1) or grey sandtex (4.3.5.6) or black sandtex (4.3.5.7)

or green sandtex (4.3.5.8) per DART QSI 005 4.3

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Feb 23, 2005
02:12 pm

Work Order No	:	0022542	Department Code:		
Project Name	:	D2808	Burden Flags	:	NNNNNNN
Project For	:	WK513	WO Status	:	Open
Work Order Type	:	Main	Invoice State	:	Not Invoiced
Main WO Number	:		Invoice Date	:	
House Part Number	:	D2808	Invoice Number	:	
Description	:	Spacer	Invoice Amount	:	0.00
Manufactured	:	Yes			
Amount Req'd	:	80	Order Entry No	:	
Amount Done	:	0	OE Value	:	0.00
Start Date	:	02-23-05			
Est Finish Date	:	03-15-05	Est Margin	:	0.000%
Act Finish Date	:		Actual Margin	:	0.000%
Drawings Reqd	:	No			
Ok for Approval	:				
Approval Rec'd	:				\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	:	0.00	0.00	0.00	0.00
Engineering Hours	:	0.00	0.00	0.00	0.00
Engineering Cost	:	0.00	0.00	0.00	0.00
Production Hours	:	0.00	0.00	0.00	0.00
Production Cost	:	0.00	0.00	0.00	0.00
Packaging Hours	:	0.00	0.00	0.00	0.00
Packaging Cost	:	0.00	0.00	0.00	0.00
OverHead Hours	:	0.00	0.00	0.00	0.00
OverHead Cost	:	0.00	0.00	0.00	0.00
CNC Hours	:	0.00	0.00	0.00	0.00
CNC	:	0.00	0.00	0.00	0.00
Misc. Hours	:	0.00	0.00	0.00	0.00
Misc.	:	0.00	0.00	0.00	0.00
<hr/>					
Burden	:	0.00	0.00	0.00	
<hr/>					
Total Cost	:	0.00	0.00	0.00	
Margin	:	0.000	0.000		
Selling Cost	:	0.00	0.00		

	Estimated	Actual	
Labour Hrs/Amount Done	:	0.00	0.00
Profits/ (Loss)	:	0.00	0.00

DART AEROSPACE LTD 30	Work Order:	22542
Description: SPACER	Part Number:	D2808
Inspection Dwg: D2808 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	Audited by:	Prototype Approval:
Date: 05.03.03	Date: 05.03.03	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	